

Date: Tuesday, 7/17/2007 2:01:05 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 33596		
Estimate Number	: 11078		
P.O. Number	: <u>NIA</u>	Part Number	: D2990041
This Issue	: 7/17/2007 S.O. No. : <u>NIA</u>	Drawing Number	: D2990 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>NIA</u> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: <u>NIA</u>	Material	: <u>NIA</u>
Written By	: <u>07.07.17</u>	Due Date	: 8/10/2007
Checked & Approved By	: <u>07.07.17</u>	Qty:	7 Um: Each
Comment	: Est B 05.02.22 Revised Step 6 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D28051	Stop
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s)

STOP

Pick:

Qty Part Number

Description

Batch

1

D2805-1

Stop

D30819mf 07-08-16

2.0	D29901	Bracket
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8 7.0000 Each(s)

Bracket

Pick:

Qty Part Number

Description

Batch

1

D2990-1

Bracket

B33001mf 07-08-16

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-1 into arm as per Dwg D2990

mf 07-08-16

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

mf 07-08-16 x8

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

mf 07-08-22 x8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:01:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 33596

Part Number: D2990041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-08-27

7.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

M101884 -

PU

8.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 14.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

2

MS21042L3

Nut

M104936

PU

9.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4 NAS1515H3

Washer

M100993

PU

A/R

LPS-3

Corrosion Spray

M104929

PU 07/12/2007

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2990

Assemble as per Dwg D2990.

mf 07-08-27

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mf 07/08/2007

(+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes NO DQA: D Date: 07/08/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/17/2007 2:01:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 33596

Part Number: D2990041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/18/28 *(8)*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

07/18/28

Job Completion



U 07-08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

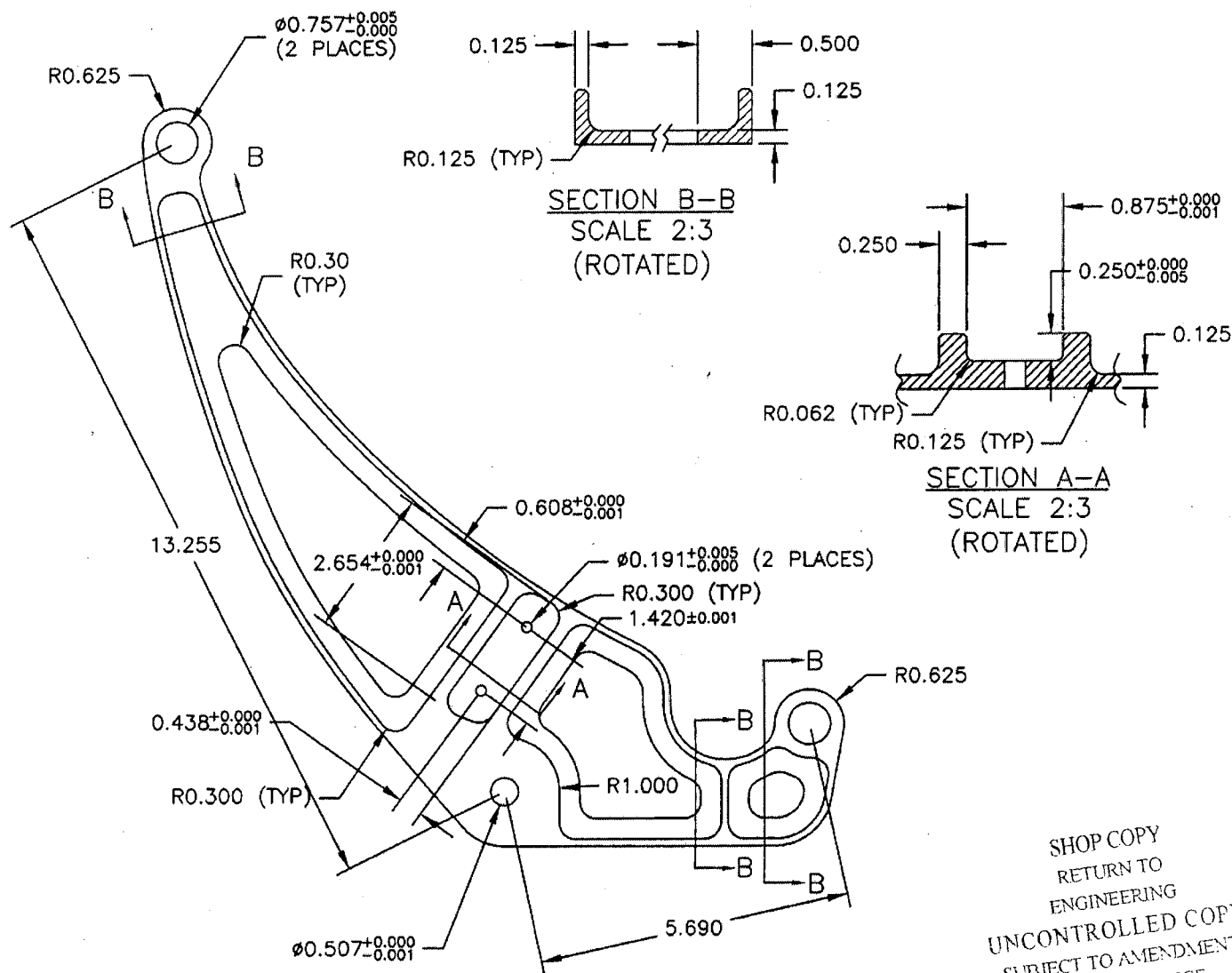
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2990	SHEET 1 OF 2
DATE	05.01.20	TITLE	STA 129 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	05.01.20	ADD CUTOUTS & -043/-044			

RELEASED05.03.11 *[Signature]***D2990-1 BRACKET (SHOWN). D2990-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2990.SLDPR1"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **33596**

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

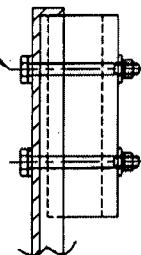


DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2990	REV. B SHEET 2 OF 2
DATE 05.01.21		TITLE STA 129 BRACKET	SCALE 1:3

RELEASED

05.03.11 #

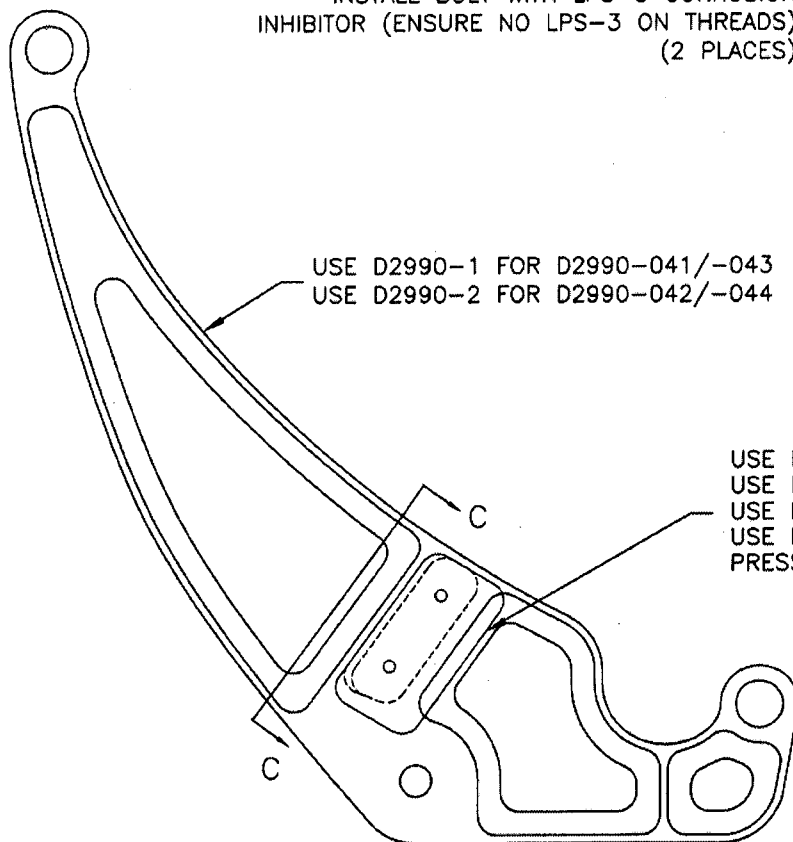
AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2990-1 FOR D2990-041/-043
USE D2990-2 FOR D2990-042/-044

USE D2805-1 FOR D2990-041
USE D2805-2 FOR D2990-042
USE D2805-3 FOR D2990-043
USE D2805-4 FOR D2990-044
PRESS INTO PLACE PRIOR TO POWDER COAT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE.
WORK ORDER
NO. 33596

D2990-041/-043 BRACKET ASS'Y (SHOWN).
D2990-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.